

Date: Monday, 6/5/2006 7:46:59 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 27361		
Estimate Number	: 11845		
P.O. Number	: N/A	Part Number	: D2346
This Issue	: 6/5/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2346 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: B
	Type : MACHINED PARTS	Material	: N/A
Written By	: <i>See Comment Below</i>	Due Date	: 6/20/2006
Checked & Approved By	: <i>06-06-05</i>	Qty:	20 Um: Each
Comment	: Est. G 02.03.05 Re-format to machine in house NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0375W035	6061-T6 Tube .375 x.035W
Comment: Qty.: 0.1094 f(s)/Unit Total: 2.1882 f(s) 6061-T6 Tube .375 x.035W Material: 6061-T6 (WW-T-700/6) .375 Ø x 0.035 wall. Batch <i>M17666</i>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA198 <i>N/A Machined Manually</i> Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/06/20 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5740

06/06/21 (20)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/21 (20)

Job Completion



06.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

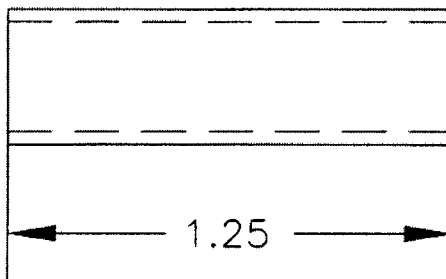


DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2346	REV. 8 SHEET 1 OF 1
DATE 99.12.15		TITLE SPACER	SCALE 2:1
A	95.01.05	NEW ISSUE	
B	99.12.15	ADD FINISHING	

RELEASED
99.12.21 DS
UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
JB BEFORE MANUFACTURE



MATERIAL: 6061-T6 (WW-T-700/6) 0.375 DIA x 0.035 WALL
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK SHARP EDGES 0.010 TO 0.020

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27361

